



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

Tel (613) 632-5200

D5520-1

Job Sheet 179499



Part No: D5520-1

Job Qty: 20 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 6/19/18

Job Tracking No:

Due Date: 6/29/18

Created By: Jesse White

Type: SOLD

Description:

Note: DWG D5520 REV.A IPP REV:A 17.05.12 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		6/29/18	0.00	0.00	Start Up Waterjet		SC 18/06/20
100	Waterjet	20 pcs		6/29/18	0.00	2.50	Waterjet1		SC 18/06/20
110	QC	20 pcs		6/29/18	0.00	0.00	QC2 Waterjet-4		SC 18/06/20
120	QC	20 pcs		6/29/18	0.00	0.00	QC8-6		38
130	Brake NC	20 pcs		6/29/18	0.00	1.33	Brake NC 1		SEP 06 2018 DAS
140	QC	20 pcs		6/29/18	0.00	0.00	QC5		SEP 06 2018 68
150	HandFinish	20 pcs		6/29/18	0.00	1.00	HandFinish1		P.R 18/09/2018
160	QC	20 pcs		6/29/18	0.00	0.00	QC7-5		SEP 09 2018
170	SprayPaint	20 pcs		6/29/18	0.00	3.33	Spray Paint		SEP 09 2018
180	QC	20 pcs		6/29/18	0.00	0.00	QC3		38
190	Packaging	20 pcs		6/29/18	0.00	0.00	Packaging3-2		38
200	QC21-SA	20 Ea		6/29/18	0.00	0.00	QC21		SEP 17 2018

Part Op 100 - 1-Cut as per Dwg ***VERIFY GRAIN DIRECTION*** Dwg Rev: A Prog Rev: A 2-Debur if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - FORM TO CORRECT RAD AS PER DWG "USE THE INSIDE EXTRUSION D2962 FOR FIT TEST"

140 - QC5- Inspect part completeness to step on W/O

150 - Chemical Conversion Coat per QSI005 4.1

160 - QC7-Inspect Chemical Conversion Coat

170 - Prime as per Dart QSI 005 4.2 Primer Batch: 138862

180 - QC3- Inspect Part Finish

190 - Identify as per dwg & Stock Location:

200 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.188	6061-T6 .188 Sheet	3.3200 sf (.166 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.188	3	46	0



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Date: 06/20/18

Part Specifications

Specifications could not be found.

Plex 6/19/18 3:40 PM dart.white.jesse